

Date: Thursday, 24/07/2008 3:13:55 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-558-041

Job Number : 40748-1

Estimate Number : 10804

P.O. Number :

Part Number : D206558041

This Issue : 24/07/2008 S.O. No. :

Drawing Number : ECN08-504

Prsht Rev. : NC

Project Number :

First Issue : 1/1 Type : SMALL / MED FAB

Drawing Revision :

Previous Run : 00015

Material :

Due Date : 05/08/2008

Qty: 18 Um: Each

Written By :

Checked &amp; Approved By :

Comment :

Additional Product

Job Number:



<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D206-558-041	CHG	CHG006		
DESC.	Single Cargo Mirror Assy	STC	SH92-17		
LOT	B38580	STC	SH1031NE		
MODEL	206A/B/L/L1/L3/L4/407	STC			
MADE IN CANADA				D2729-1	

Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3X D206-558-041 B 38580 ✓ FFx3 08-07-30

PULL FROM STOCK:

3 X D206-558-041 B39281

10 X D206-558-041 B39398 ✓

5 X D206-558-041 B39399 ✓

FFx10 } 08-07-30  
FFx5 }

2.0

D206558041

Single Cargo Mirror Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)

Single Cargo Mirror Assembly

3.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

CUT ARMS TO REMOVE ALL COMPONENTS

D2011-101 MIRROR

D2052 MTG BRKT

D2054 BUSHING

D2055 CLAMP

D2056 BELL CRANK

D2057 PLUG

PUT COMPONENTS ASIDE TO RE-USE WITH NEW ARM

DISCARD HARDWARE

MANUFACTURE NEW ARMS WITH .049 WALL MAT'L

FF 08-07-30

— FF 08-07-30

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Description :

4.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 1.7500 f(s)/Unit Total: 31.5006 f(s)  
304 RD Tube .500 x .049W  
304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012  
(M04TR0.500W049)  
Identify as D2065.  
Note: 1 end only  
Batch 108324  
FF 08-07-31 (10)

take 10x D2065 from B40580

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE  
Punch 1/2" OD x .035" Wall AISI

Signed for SR.

FF 08-07-31 - (10)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Cut to length as per Dwg D2065  
Bend as per Dwg D2065 and template D2065T1  
Flatten the end on Hydraulic press using Dt 8545  
Drill 00.188" holes as per Dwg D2065 and template D2065 T1 and using Dt 8768 Drill Jig.  
Deburr.

FF 08-07-31 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S. 08/07/31 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

102316

(10X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00  
320  
11:30

M-H

08/07/31



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Drawing Name: D206-558-041

Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/07/31

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



P10

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-558

USING ORIGINAL COMPONENTS  
AND NEW HARDWARE:

FF 08-07-31

①

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 72.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

4 AN960JD10

Washer

M100550

FF 08-07-31

①

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 36.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut

M107665

or MS21042-3

FF 08-07-31

①

13.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 36.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-18

Screw

M100161

FF 08-07-31

①

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/31

ⓧ

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR  
ORIGINAL KITS TO BE INCLUDED.

08/07/31 (R)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REPACKAGE PER PPP  
USING NEW B/N @ CHG 007  
NEW LABELS REQUIRED  
ADD PAPERWORK DSI 9416

08/07/31

08/07/31 (C)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/31

Job Completion



MF 08-07-31



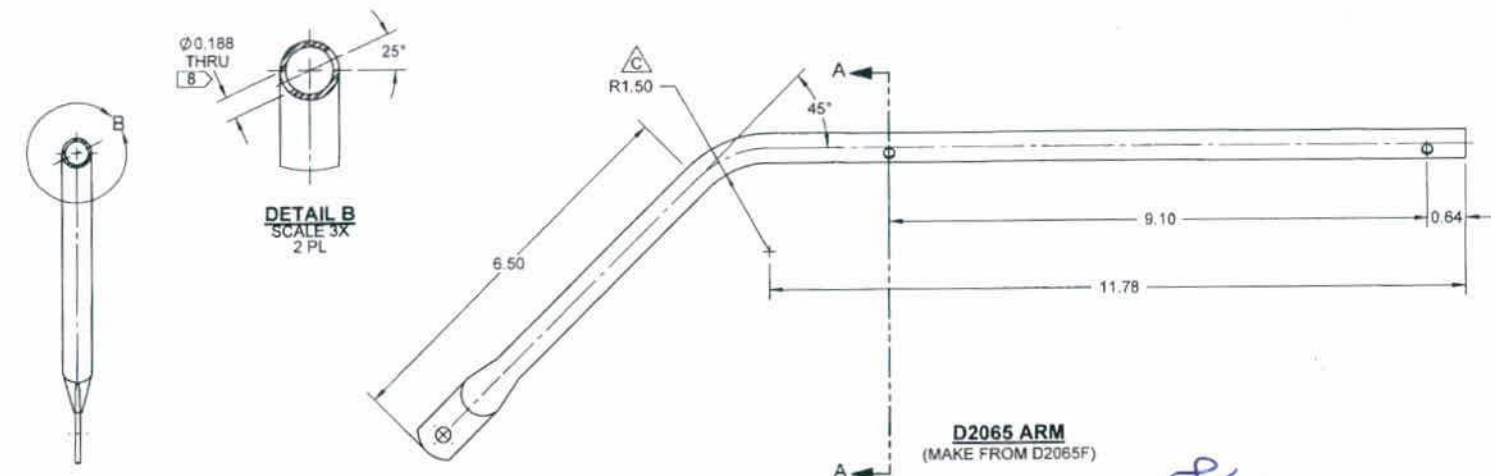
D2065 ARM

*w/o  
40248*

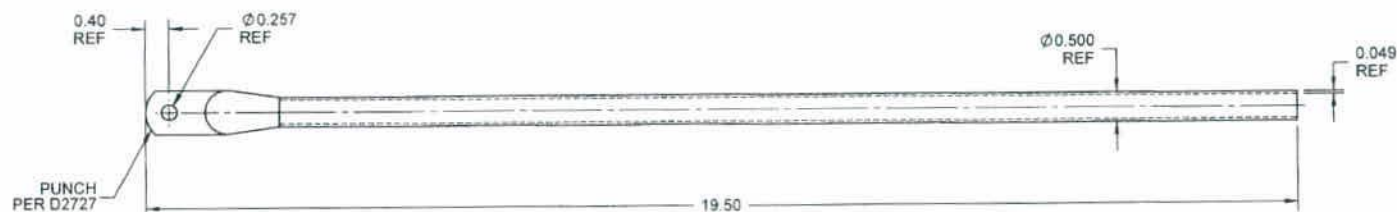
**RELEASED**  
(08-07-23.17)

C	REDRAWN IN SOLIDWORKS, INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø 0.500 X 0.049 WALL WAS Ø 0.500 X 0.035 WALL (ZN A3-2); REASON: Ø 0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.13
B	RE-DESIGN	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2065</b> REV. C SHEET 1 OF 2 TITLE <b>ARM</b> SCALE NTS COPYRIGHT © 1992 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.13		

8 7 6 5 4 3 2 1



SECTION A-A



D2065F ARM CUT LENGTH DETAIL

*84L of 9M*

NOTES:

- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\phi 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL  $\phi 0.188$  AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2065	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD	
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RELEASED  
08.07.2014

8 7 6 5 4 3 2 1



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-558-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/08/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>40748</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/07	# 10.0	Disarm Disassembly He 220ST Plugs were not saveable Due to the inside <del>disorder</del> the tubing changed.	 08/10/07	Scrap all Plugs with Arms and <del>Real</del> Pull from stock B# <u>B40048</u>	08/07/31 FF	08/07/31 FF	 08/10/07	 08/07/07

NOTE: Date & initial all entries